Quality Control

Work Order Thursday, March (Page 1
Revision ID:	03275-1 Prossbolt Space	er		Accept					Setup	Start Stop		
	/3/2011	Start Qty: 100.00 Req'd Qty: 100.00		1 1 1 1 1 1 1 1 1 1	Cust Item I Customer:	D:						
	Process Plar QC:	1:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr D3275	Revi	sion Nbr A1										4.118.0
Hardinge CNC Lathe S	Small	Hardinge CNC LATHE S Memo 1-Turn as per		0.00 0.00 and Dwg D3275 /// 3/7				101	1 -5	b		
QC Quality Control		QC2- Inspect parts off ma	chine FAI/FA	0.00 0.00 1JJ7				107	1 8	<u></u>		
						٠			-			.**
120 		QC8- Inspect parts - secon	nd check	0.00 Onk	11/03/07			10	Z	B		

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W/O:			WO	RK ORDER CHANG	iES				
DATE STEP		PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							į		
								3	
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	Date: _	
	Res	solution:	Disposition	:	_ QA: N/C (Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector
				•					

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NOTE: Date & initial all entries

Work Order ID 66930

Thursday, March 03, 2011 7:50:48 AM



Page 2

Item ID:

D3275-1

Accept

Tool # Plan

Code

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 3/7/2011

Crossbolt Spacer

3/3/2011

Start Qty: 100.00

Reg'd Qty: 100.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Start Run

Reject

Qty



QC:

Date:_____

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Packaging Packaging

130

Operation Description

Identify as per dwg & Stock Location:

STOCK IN SKIDTUBE CELL

Set Up/ **Run Hours**

0.00

0.00

Accept

Qty

CY 11/03/12

Reject

Number

107

Insp.

Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

1/3/14 A

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W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,				
				·						
Part No	•	PAR #:	Fault Cate	egory:	NCI	R: Yes	No DQ	A:	Date:	
		esolution:								
NCR:			WORK ORE	ER NON-CONFOR	RMANCE	(NCR)			
DATE	OTED	Description of NC		Corrective Action	Section B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descripti	ion 	Sign & Date	Secti		Chief Eng	QC Inspector
				· ·	∧ .					
	·									

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 7:50:45 AM

Work Order ID: 66930

Parent Item: D3275-1

Parent Item Name: Crossbolt Spacer



Start Date: 3/3/2011

Required Date: 3/7/2011

Page 1

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP Rev:A□04.10.19□New issue□KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05		Purchased	No			100	f	189.4840	0.2666	28.06316			
						•				12	1113	17	

ALUM TUBE .3125 x .058w

Location	Loc Qty	Loc Code	
MAT ₋₁	189.484		
. 116793	3.684		
116939	185.8		

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W/O:			W	ORK ORDER CHANG	GES				,
DATE STEP		PR	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·					:		
							į. Į		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	 A:	Date:	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NC	R)			
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector
		.							
	1		Į l						1

NOTE: Date & initial all entries

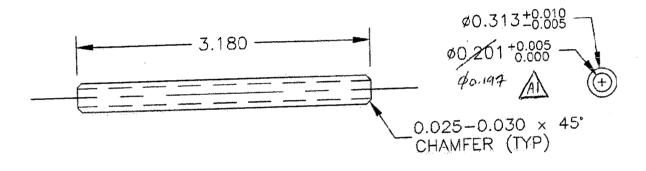




	DESIGN	W	DRAWN BY	DART AEROSPACE USA PORT HADLOCK, WA	A, INC.
1		- 1	APPROVED /	DRAWING NO.	REV. A
	CHECK	A	#	D3275	SHEET 1 OF 1
	DATE"	11)		TITLE	SCALE
	04.0	3.10		CROSS BOLT SPACER	1:1
	Α	. ;	04.03.10	NEW ISSUE	-
	<u> </u>	10 11	04 10 19	CHANGE MAT'L SPEC	

RELEASED

w/066930



D3275-1 CROSS BOLT SPACER

1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M60617670:313W.058 A)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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TOO DAGE LED	Work Order:	do 930 ·
DART AEROSPACE LTD	Part Number:	D3275-1
Description: Crossbolt Spacer		
Inspection Dwg: 03275 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	_	
X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+/-0.010	3.177			Veh	201.
0.025 - 0.030	N/A	0307				
45°	+/-0.01°	750				
Ø0.313	+0.010/-0.005	310				
0.058	Max = 0.0605 Min = 0.0555	-059				_
				.,,,,,,,		

- 1		<u> </u>		
		1 Sml	Prototype Approval:	N/A
	Measured by:	Audited by:	Date:	N1 (A "
	Date: 1//3/7	Date: 11/03/07		Angroved

	Dato.	Revised by Approved
Rev	Date	Change KJ/JLM
A	04.10.19	New Issue KJ/JLM A
B	06 03 09	Dimension Ø0.197 was Ø0.201 KJ/DD
c.	09.05.04	Ø0.197 dimension removed